

**Garant**
**GARANT Master Tap machine tap HSS-E-PM extra long Form B 6HX, AlTiX, M: M6**

**Order data**

Order number	131770 M6
GTIN	4045197901323
Item class	111

**Description**
**Version:**

**Universal taps**, designed for use in a wide spectrum of materials with high process reliability.

- **HSS-E-PM tool material for a high degree of wear resistance.**
- **Reduced coefficient of friction due to the new high-performance coating.**
- **Special geometry for optimum swarf evacuation.**

Shank to DIN 371.

**Advantage:**

Designed for tapping threads where access is difficult.

**Technical description**

Thread $\varnothing$	6 mm
Standard	Manufacturer's standard
Number of cutting edges Z	3
Shank square $\square$	4.9 mm
Thread type	M
Number of clamping slots	3
Shank $\varnothing D_s$	6 mm
Thread pitch	1 mm
Overall length L	160 mm
Thread size	M6

Thread depth	18 mm
Tolerance class	ISO 2X 6HX
Tool material	HSS E PM
Tapping hole Ø	5 mm
Coating	AlTiX
Flank angle	60 degrees
Thread standard	DIN 13
Taper lead form	B
Shank	Plain shank with h9
Through-coolant	no
Application for type of drilling	up to 3×D for through holes
Cutting direction	right-hand
Type of threading tool	Machine tap for dynamic machining
Colour ring	green
Series	Master Tap
Type of product	Tap

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	24 m/min	N
Aluminium (short chipping)	suitable	28 m/min	N
Alu > 10% Si	suitable	16 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	24 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	8 m/min	M

INOX > 900 N/mm <sup>2</sup>	suitable	6 m/min	M
GG(G)	suitable	16 m/min	K
CuZn	suitable	16 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		